

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001008**Date Inspected:** 12-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 615**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** William Norris**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) test**Summary of Items Observed:**

The Quality Assurance (QA) Inspector arrived at the Ironworkers Apprenticeship Training Facility and met with Smith-Emery Company Quality Control (QC) Inspector William Norris to observe QC functions during the welding of the Procedure Qualification Record (PQR) test plate listed below.

ABF-PQR-026-2-A.

1. The QA Inspector periodically observed American Bridge Floor (ABF) welding personnel Rick Clayborn perform air carbon arc cutting (gouging) and grinding on test plate identified as ABF-PQR-026-2-A. The cutting was being performed to remove run off weld tabs and the grinding to remove the weld reinforcement to a smooth and flush finish to prepare test plate for final inspection and future Non Destructive Testing.

a) After cutting and grinding were completed the PQR test plate was visually inspected by QC Inspector William Norris. William Norris notified the QA Inspector the test plate was visually acceptable in accordance with AWS D1.5-2002. The QA Inspector performed visual verification and observed test plate appeared to be in general compliance with the project plans and specifications.

b) QA Inspector assigned a Caltrans Index Lot Number to test plate for tracking purposes and a Welding Witness Report (TL-6032) was generated on this date. Please see digital image below.

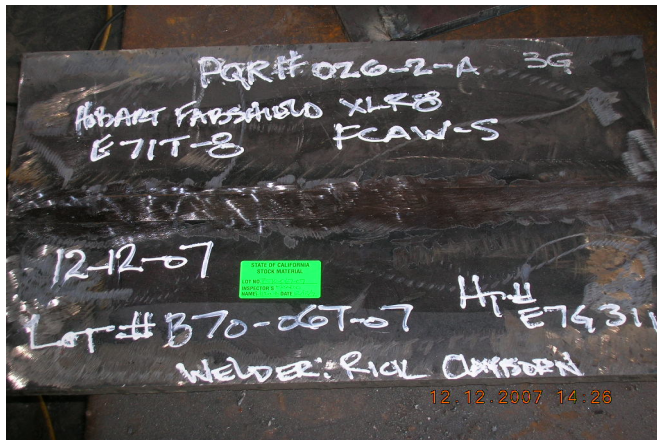
ABF-PQR-028-1.

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2. Prior to starting welding PQR test plate QC Inspector William Norris informed the QA Inspector he had accepted the fit up of the weld joint. The QA Inspector verified the weld joint to be a standard butt joint B-U2a-GF intended to be a CJP groove weld. The QA Inspector performed a random visual verification of the fit up of the plates and observed the joint to be un accordance with figure 2.4 of the AWS D1.5, 2002.

a) QA Inspector periodically observed American Bridge Floor (ABF) welding personnel Rick Clayborn and Daniel Gordon preparing welding equipment, welding material and welding using practice material prior to starting welding to make Complete Joint Penetration (CJP) groove weld of the Procedure Qualification Record (PQR) test plate identified as ABF-PQR-028-1. QA Inspector observed Lincoln Electric manufacture electrode representative assisting ABF welding personnel with the settings of the recommended electrical welding parameters of the use electrode for the welding of the test plate. QA Inspector was notified by ABF welding foreman Rick Clayborn that no welding will be performed on the testing plate at this time due to welding equipment and electrical welding electrode parameters not being set.



Summary of Conversations:

As noted in the body of the report above. Other basic communication was performed between QA Inspector and the QC Inspector William Norris during observations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Medina,Ricardo

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer